

Work Order ID 80186

Monday, February 13, 2012 2:31:40 PM

80186

ASAP

Page 1

Item ID: D3589-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: ARM

Start Date: 2/13/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/16/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: *MUF*Date: *12-02-13* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3589

Rev B

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1- cut D3589-1 as per dwg D3589
2- chamfer both ends as per dwg D3589
3- deburr*8* 10 *FF* 12-02-14

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

*5 12/02/14**(40)*

120

Identify as per dwg & Stock Location: *WA*

0.00

120

Packaging

Memo

0.00

Packaging

12/2/14 *(10)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

[Handwritten signature] M.L.J 12/02/15

M.L.J 12/02/15

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Picklist Print

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Page 1

Work Order ID: 80186

Parent Item: D3589-1

Parent Item Name: ARM

Start Date: 2/13/2012

Required Date: 2/16/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-05-29 new issue DD verified by:EC
dwg DD verified by:EC IPP Rev:B 09-02-20 rev.b asper

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.375W.065 304 RD Tube .375 x .065W		Purchased	No			100	f	52.2500	1.65	16.582915	10	FF 12-02-14	

Location

Loc Qty

Loc Code

MAT016

52.25

111097

1.75

120183

50.5

16.502

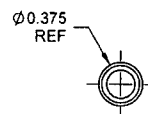
W/O:		WORK ORDER CHANGES					
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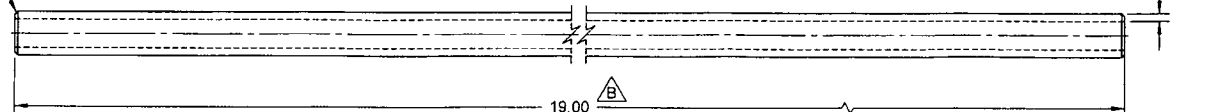
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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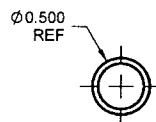
0.03 X 45°
CHAMFER
2 PL



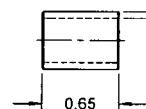
0.065
REF

D3589-1 ARM

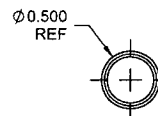
80186



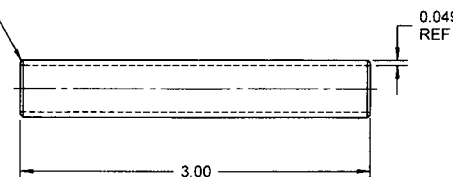
0.058
REF



D3589-3 ARM GUIDE



0.03 X 45°
CHAMFER
2 PL



0.049
REF

D3589-5 LATCH GUIDE

D3589-1/3/5 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
- D3589-3 = 0.01 lbs
- D3589-5 = 0.06 lbs

RELEASED
09/02/05

DESIGN	JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JH		
CHECKED	PH	DRAWING NO. D3589	REV. B
MFG. APPR.	PH	SHEET 4 OF 8	
APPROVED	JH	TITLE	SCALE
DE APPR.	JH	LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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